

ASAP for Eagle!

Dart Aerospace Ltd.

Date: Monday, 15/12/2008 3:14:00 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TAIL LIGHT FAIRING
Job Number : 44095	
Estimate Number : 12364	
P.O. Number :	
This Issue : 15/12/2008 S.O. No. :	Part Number : D3484041
Prsht Rev. : NC	Drawing Number : D3484 REV E
First Issue : / /	Project Number : N/A
Previous Run : 43276	Drawing Revision : E
	Material :
Written By :	Due Date : 22/12/2008
Checked & Approved By :	Qty: ② cpl Um: Each
Comment : Est Rev: A New Issue 06-04-11 JLM Est Rev: B 08-01-24 change rivet to CR1122-3-025 DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34841	Base, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
BASE, LH
Batch: B 34456-1

SP 08.12.18.

2.0	D34843	Face, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
FACE, LH
Batch: B 4325-1

SP 08.12.18.

3.0	D34845	Cone, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
CONE, LH
Batch: B 36402-1

SP 08.12.18.

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig
A/R AL ROD Batch: M 104855

2-Buff & Smooth Welds to mating surfaces

SP 08.12.22


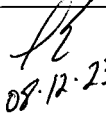



②x

SP 08.12.18

PRU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3484-041 PAR #: N/A Fault Category: Prod/Ins. Log. NCR: Yes No DQA: D Date: 05/01/06
 Resolution: D412-750-141 Re-work Disposition: Re-work QA: N/C Closed: D Date: 09/01/06

NCR: <u>44095</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>05-12-23</u>	<u>4.0</u>	<u>Part is cracked at the</u> <u>rod weld location.</u> <u>R.C: Ground too much. Human</u> <u>error.</u>	 <u>Resistor</u>	<u>re-weld affected area</u> <u>& grind smooth.</u>	 <u>05-12-23</u>	 <u>05-12-23</u>	 <u>Resistor</u>	 <u>05-12-23</u>

NOTE: Date & initial all entries

Date: Monday, 15/12/2008 3:14:00 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 44095

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/08/12/23 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/06/12.23 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/12/29 (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/12/29 (2X)

9.0

CR1122 3 025

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Rivet

Batch: 106878

FF 09-01-05

(2)

10.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

ANCHOR NUT

Batch: 103693

FF 09-01-05

(2)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

FF 09-01-05

(2)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/09-01-05 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 15/12/2008 3:14:00 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 44095

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

POWDER COATING

POWDER COATING



M/09996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:40

OVEN TEMPERATURE:

320°

FINISH TIME:

2:10

FL 09/01/05

(2)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



44



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-01 (X2)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N:D412-750-141 B/N:BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

JS 09/01/05 (X2)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/05 (+144)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/06

Job Completion



MF 09-01-06

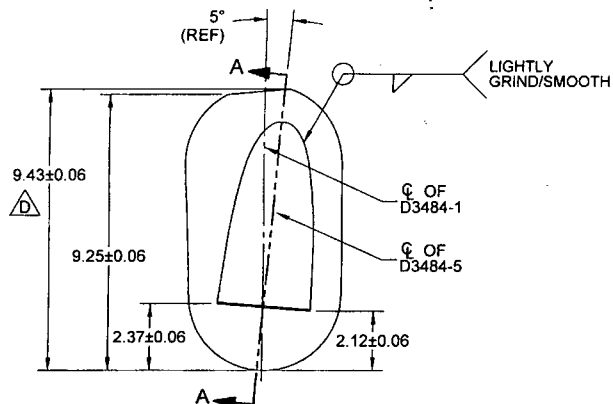
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

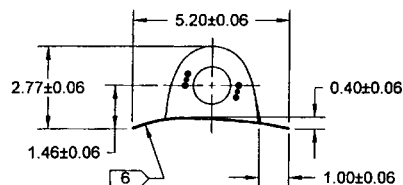
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

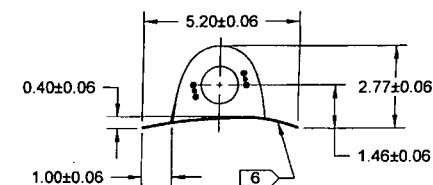
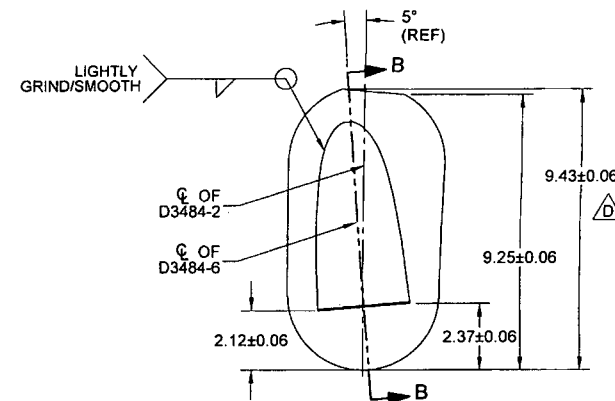


QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
		D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT



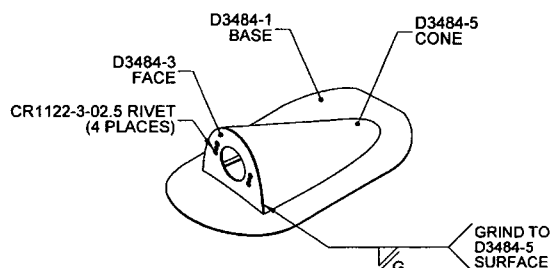
SECTION A-A

D3484-041 TAIL LIGHT FAIRING

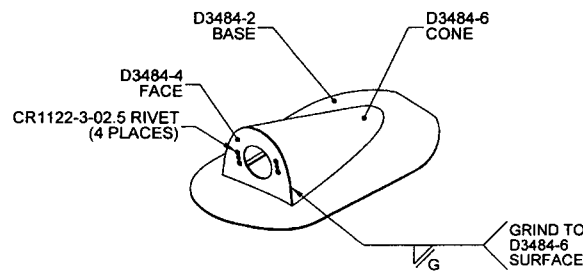


SECTION B-B

D3484-042 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW



D3484-042 ISOMETRIC VIEW

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) WELDING: PER DART QSI 004
 - 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
 - 7) WEIGHT: 0.30 lbs

E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY. CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS): DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.03		

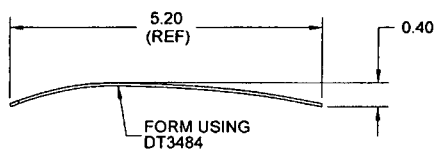
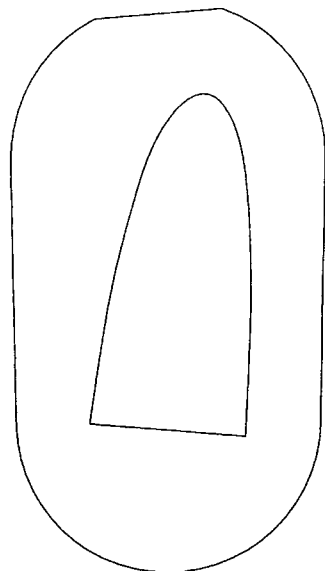
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3484	REV. E
TITLE TAIL LIGHT FAIRING	SCALE 1:4
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RELEASED
06-01-14

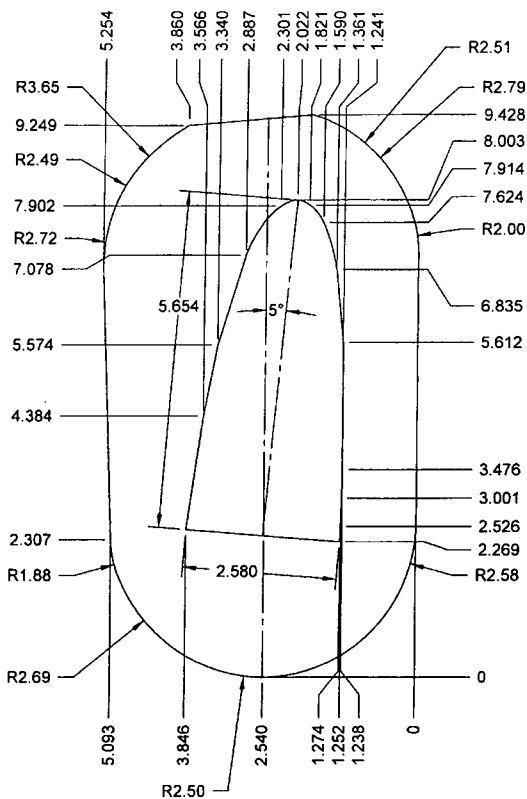
8 7 6 5 4 3 2 1

D
C
B
A

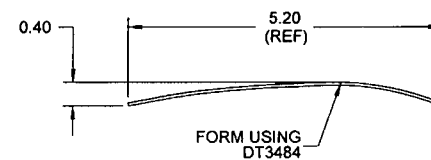
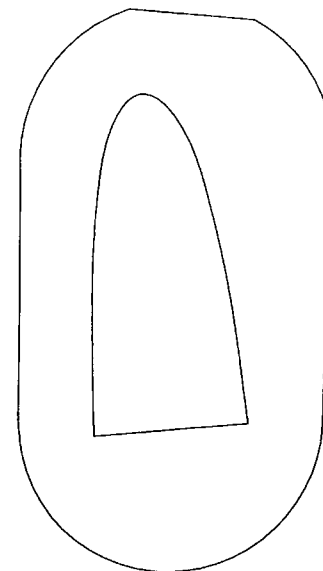
D
C
B
A



D3484-1 BASE
(MAKE FROM D3484-1F)



D3484-1F BASE FLAT PATTERN



D3484-2 BASE
(MAKE FROM D3484-1F)

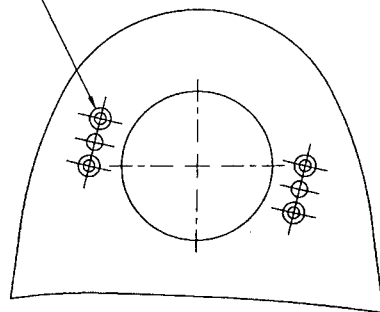
- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs

RELEASED
08-01-17/14/0

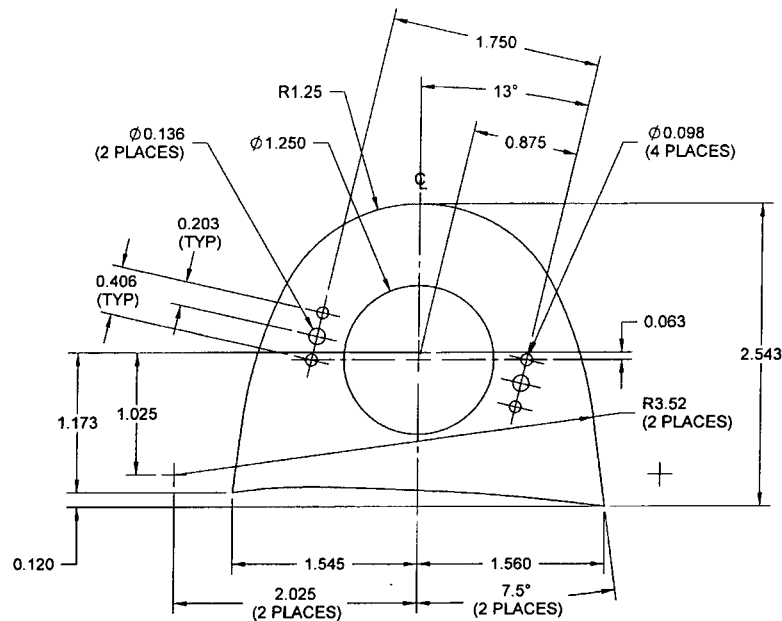
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3484	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:2
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8 7 6 5 4 3 2 1

C'SINK
 $\phi 0.181 \times 100^\circ$
 (4 PLACES)

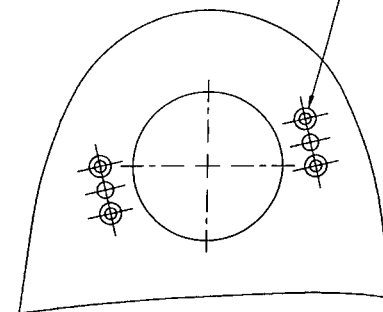


D3484-3 FACE
 (MAKE FROM D3484-3F)



D3484-3F FLAT PATTERN TAIL LIGHT FAIRING

C'SINK
 $\phi 0.181 \times 100^\circ$
 (4 PLACES)



D3484-4 FACE
 (MAKE FROM D3484-3F)

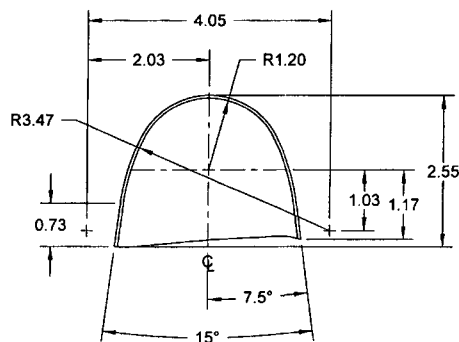
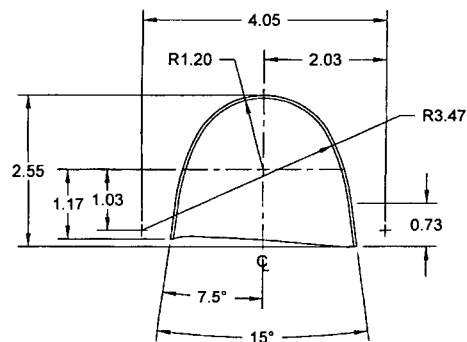
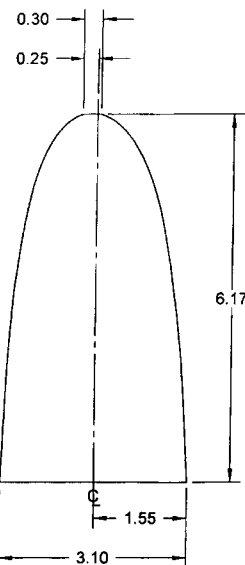
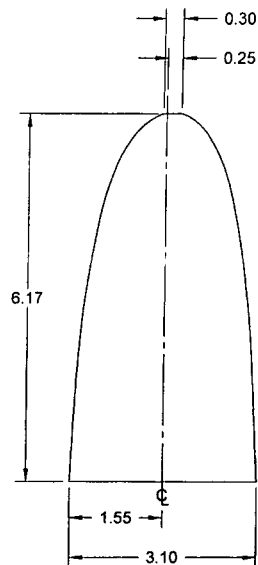
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

RELEASED
 08.01.17 M/D

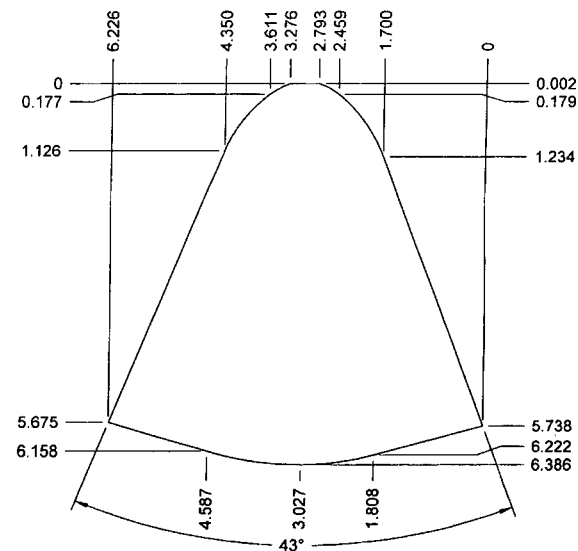
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. E
MFG. APPR.		D3484	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:1
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8 7 6 5 4 3 2 1



D3484-5 CONE
(MAKE FROM D3484-5F)

D3484-6 CONE
(MAKE FROM D3484-5F)



D3484-5F CONE FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

08.01.03

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3484	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:2
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8 7 6 5 4 3 2 1